

Work Order ID 70834

Wednesday, June 15, 2011 4:00:03 PM



Page 1

Item ID:	D2330-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Base Assembly					
Start Date:	6/21/2011	Start Qty:	1.00			
Required Date:	6/29/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<u>CMF</u>	Date:	<u>11-06-15</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2330	Rev H								

100		0.00							
Large Fab	Memo	0.00							
Large Fab	1- weld as per dwg D2330 and QSI 004								
	S.S Rod batch: <u>M115778</u>								

11.06.22.

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11.06.23

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

5/10/23

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

[illegible]

Setup Start

[illegible]

Stop

[illegible]

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves assigning tasks to team members, setting deadlines, and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[REDACTED]

**Insp.
Stamp**

0.00

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

HandFinish

Memo

0.00

Hand Finishing

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

[illegible]

Powdercoat

Powder Coating

Memo

Start Time:

Oven Temperature: _____

Finish Time:

0.00

0.00

01

0.00

0.00

140

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve researching existing solutions, consulting with experts, or collecting data.

3. The third step is to develop a plan or strategy. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of actions to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks and monitoring progress to ensure that the plan is being followed.

5. The fifth step is to evaluate the results. This involves comparing the actual outcomes with the expected results and identifying any areas for improvement.

6. The sixth step is to communicate the findings. This involves sharing the results of the analysis with the relevant stakeholders and providing recommendations for future action.

7. The seventh step is to reflect on the process. This involves considering what worked well, what challenges were encountered, and how the process can be improved for future tasks.

QC

Quality Control

Memo

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Work Order ID 70834

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Item ID: D2330-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

W/O 70832

0.00

Packaging

EF 11/06/23 ①

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/27 27**MF
11-06-23*

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 70834

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly




Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S KJ
IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verF by:EC
IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																					
D2012-107  Clevis		Manufactured	No			100	Each	21.0000	1	1																																																																								
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="11"></td></tr><tr><td>WA005</td><td>21</td><td></td><td colspan="11"></td></tr><tr><td>66811</td><td>21</td><td></td><td colspan="11"></td></tr></table>													<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>												WA005	21													66811	21																																								
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WA005	21																																																																																	
66811	21																																																																																	
D2235-1  Basket Rib		Manufactured	No			100	Each	14.0000	4	4																																																																								
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D2252-1  Frame		Manufactured	No			100	Each	16.0000	2	2																																																																								
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SAD 11-06-20

④

SAD 11-06-20

4

SAD 11-06-20

2

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Picklist Print

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Page 2

Work Order ID: 70834

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2252-7

Manufactured No

100 Each

5.0000

1

1



Frame



SAD 11-06-20

Location

Loc Qty

Loc Code

WA006

5

48324

1

61960

4

D2253-1

Manufactured No

100 Each

19.0000

2

2



Lug



SAD 11-06-20

Location

Loc Qty

Loc Code

WA005

19

53965

19

D2254

Manufactured No

100 Each

50.0000

2

2



Gussett



SAD 11-06-20

Location

Loc Qty

Loc Code

WA005

50

39801

50

D2327-3

Manufactured No

100 Each

10.0000

1

1



Spacer Bushing



SAD 11-06-20

Location

Loc Qty

Loc Code

WA005

10

70724

10

D2330-1

Manufactured No

100 Each

4.0000

2

2



Frame



SAD 11-06-20

Location

Loc Qty

Loc Code

WA006

4

61931

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 70834

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2330-5

Manufactured No

100

Each

1.0000

1

1



Frame



SAD 11-06-20

Location

Loc Qty

Loc Code

WA006

1

61876

1

1.0000

1

1

D2330-7

Manufactured No

100

Each



Frame



SAD 11-06-20

Location

Loc Qty

Loc Code

WA006

1

61877

1

74.0000

4

4

D2581

Manufactured No

100

Each



Mounting Bracket



SAD 11-06-20

Location

Loc Qty

Loc Code

WA

74

68964

6

69258

28

69739

40

11.0000

3

3

D3748-1

Manufactured No

100

Each



Hinge Half



SAD 11-06-20

Location

Loc Qty

Loc Code

WA

11

68884

11

3

Wednesday, June 15, 2011 3:59:55 PM

Shop Packet Print

Page 3

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Wednesday, June 15, 2011 3:59:56 PM

Page 4

Work Order ID: 70834



Parent Item: D2330-041



Parent Item Name: Basket Base Assembly

Start Date: 6/21/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

611.1169

30



Expanded Metal Flat SS



30

11.06.22

Location

Loc Qty

Loc Code

MAT

38.2107

117708

38.2107

WA

572.9062

115012

102

117197

134.8721

117455

16.0341

117896

320

117896

30

W/O:		WORK ORDER CHANGES					
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ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2330	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

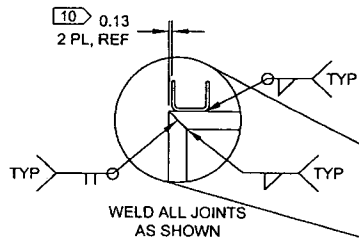
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

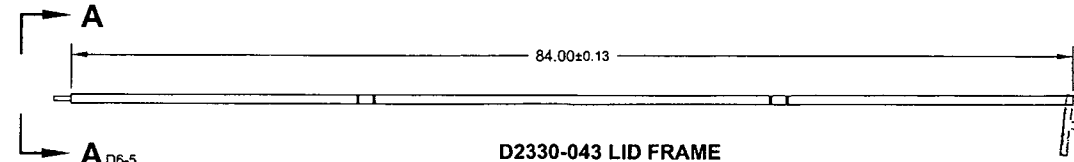
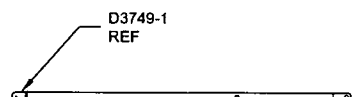
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NOTE: Date & initial all entries



SEE DETAIL G
A2-5



D2330-043 LID FRAME

LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. H
MFG. APPR.	JB	D2330	SHEET 2 OF 6
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	BASKET ASSEMBLY (206B)	NTS
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#10834

RELEASED
2010-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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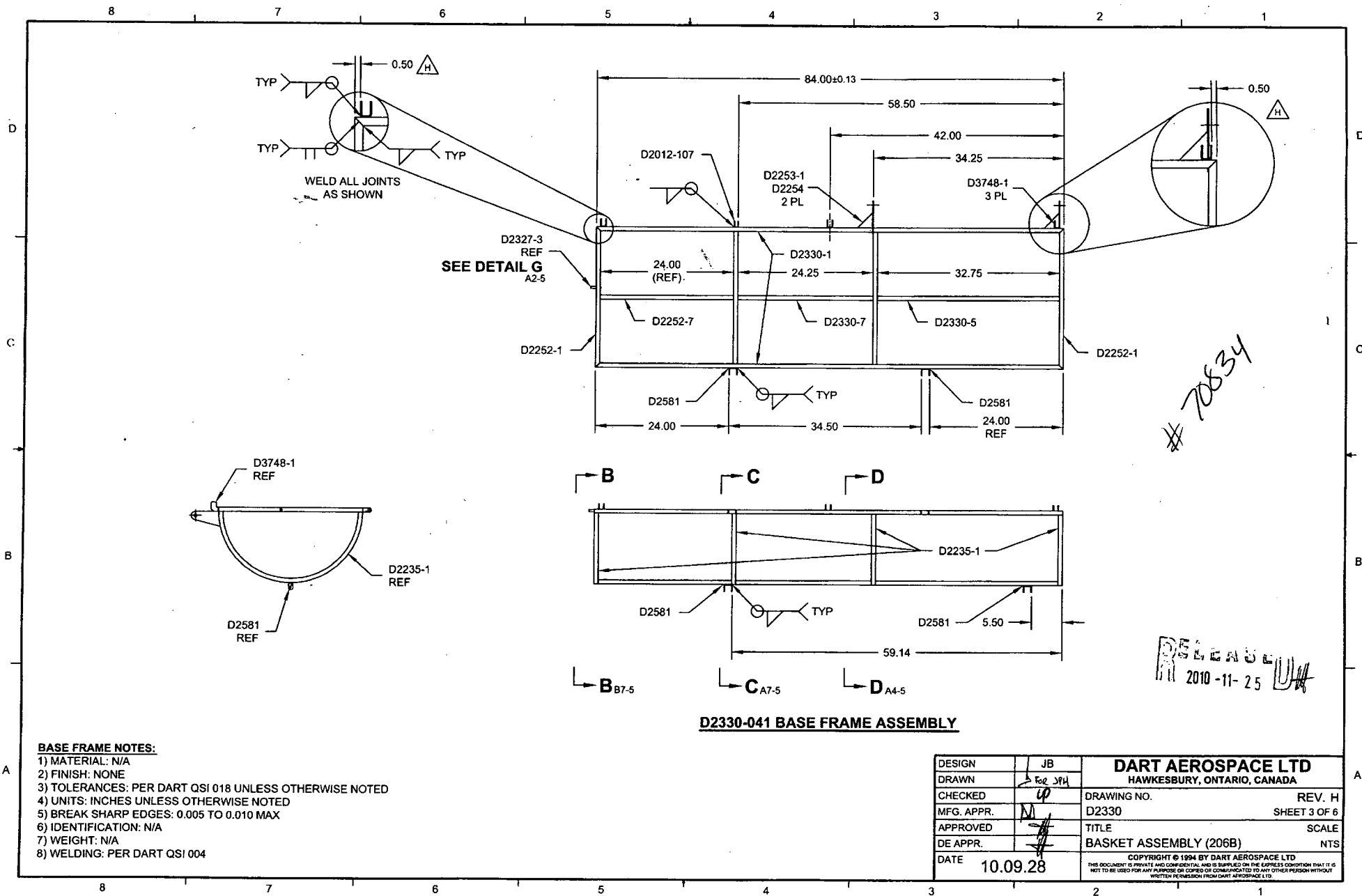
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D2330-041 BASE FRAME ASSEMBLY

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	For JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	up	DRAWING NO.	REV. H
MFG. APPR.	M	D2330	SHEET 3 OF 6
APPROVED	#	TITLE	SCALE
DE APPR.	#	BASKET ASSEMBLY (206B)	NTS
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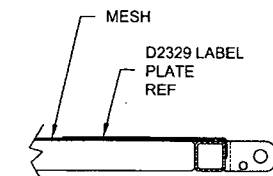
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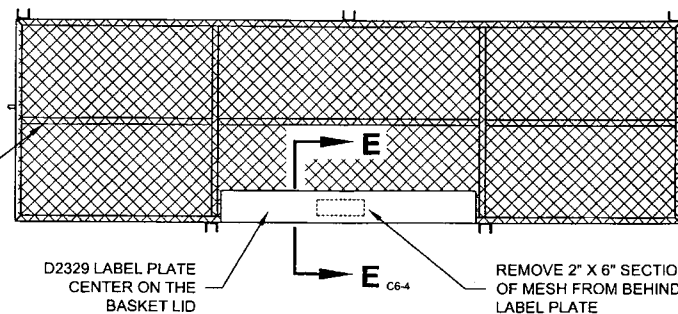
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NOTE: Date & initial all entries

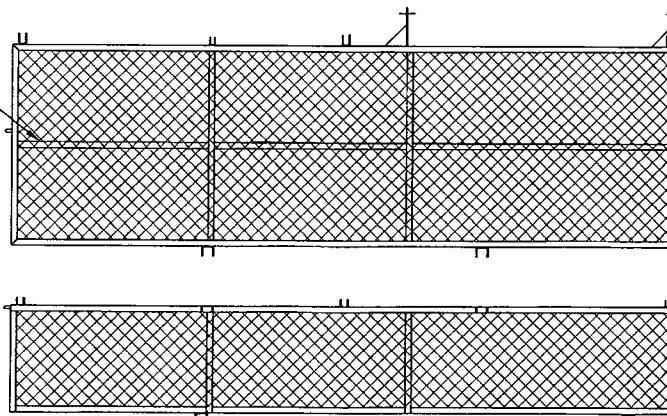


SECTION E-E C3-4
VIEW ROTATED 90° CCW

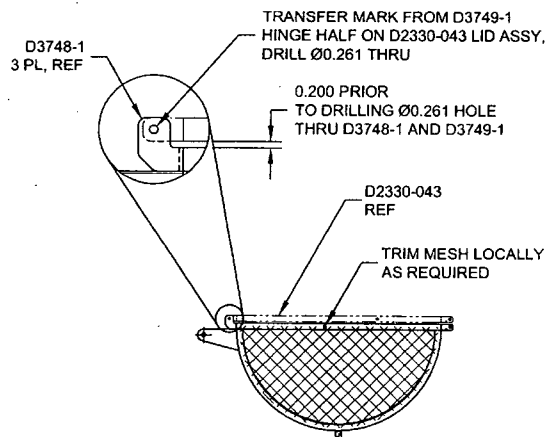
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COUNTERFEITED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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2010-11-25

70834

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

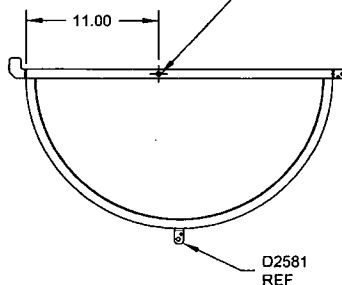
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

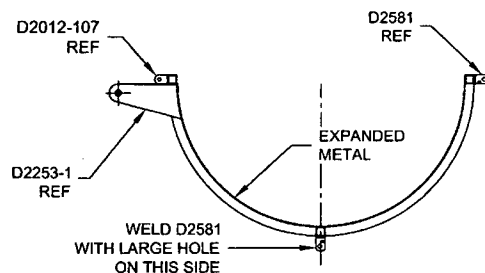


VIEW A-A A6-2

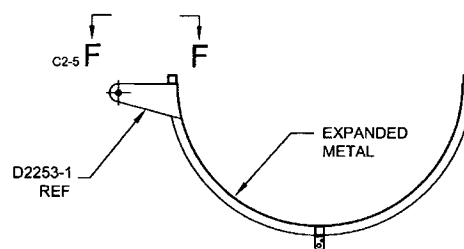
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



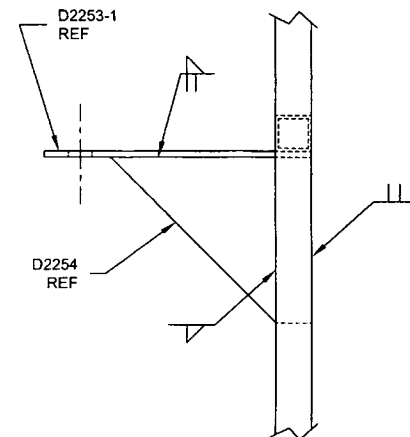
VIEW B-B A5-3



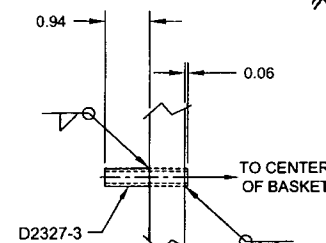
SECTION C-C A4-3



SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X

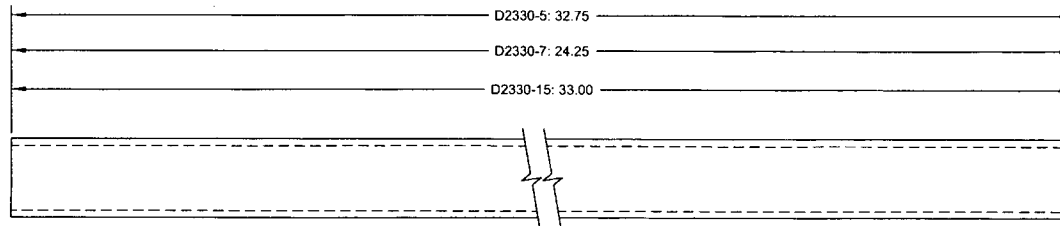
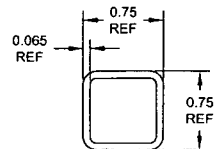


DETAIL G
SPACER INSTALLATION
SCALE 4X

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8 7 6 5 4 3 2 1

D

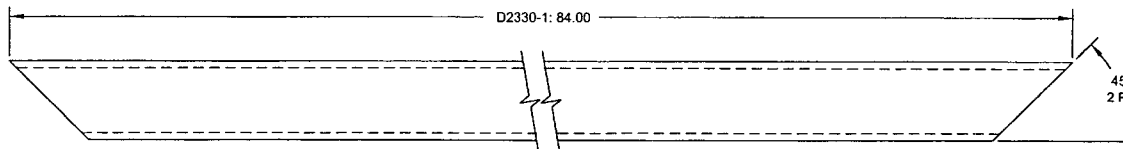
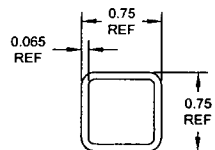


D2330-5 FRAME

D2330-7 FRAME

D2330-15 FRAME

C



D2330-1 FRAME

B






20834

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2010-11-25

A

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
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8 7 6 5 4 3 2 1